

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84756

84756

Page 2

May-22-12 3:01:36 PM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 22/05/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>out 12/06/05</i>			<i>1</i>	<i>2</i>		
--	---	------------------	---------------------	--	--	----------	----------	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>10</i>	<i>NA 120-5</i>		
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150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: <i>12:00</i> FINISH TIME: <i>12:30</i>	0.00 0.00				<i>10X</i>	<i>0</i>	<i>12/06/06</i>	<i>m-l</i>
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m121279

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

May-22-12 3:01:36 PM

Item ID: D3195-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket Assembly

Stop *NS2*

Start Date: 22/05/2012 **Start Qty:** 10.00

10

Cust Item ID:**Required Date:** 05/06/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

0.00

170

Small Fab

0.00

Small Fab

Memo

Small Fab

1-Lightly Sand bonding surface 2-Bond D3195-7 into D3195-13 as per Dwg
D3195A/R Contact Cement 120964

· 180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

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NOTE: Date & initial all entries

Work Order ID 84756

84756

Page 4

May-22-12 3:01:36 PM

Item ID: D3195-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 22/05/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 05/06/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location 246A	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

(10) 12/6/85

12/6/11

mf
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-22-12 3:01:39 PM

Page 1

Work Order ID: 84756

84756

Parent Item: D3195-043

D3195-043

Parent Item Name: Bracket Assembly

Start Date: 22/05/2012

Required Date: 05/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3195-7		Manufactured	No			100	Each	35.0000	1	10			
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D3195-7

Pad

**

(10) FF 12-06-09

Location

Loc Qty

Loc Code

GA

35

73040

1

83705

34

10

M6061T6B1.500X01.25
0

Purchased No

170

f

13.0570

0.3

3.157895

M6061T6B1 500X01 250

**

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT003

13.057

118071

0.112

119513

0.945

121660

12

3.2

PD 12/06/02

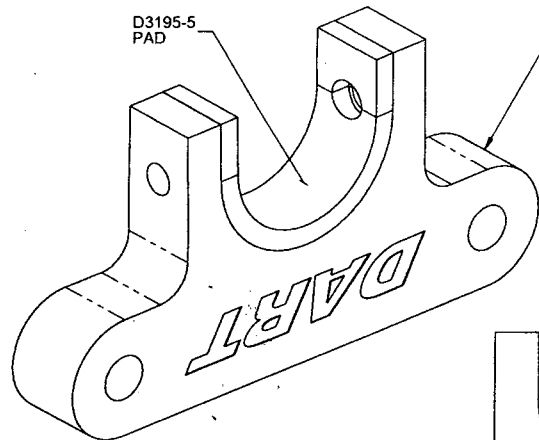
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

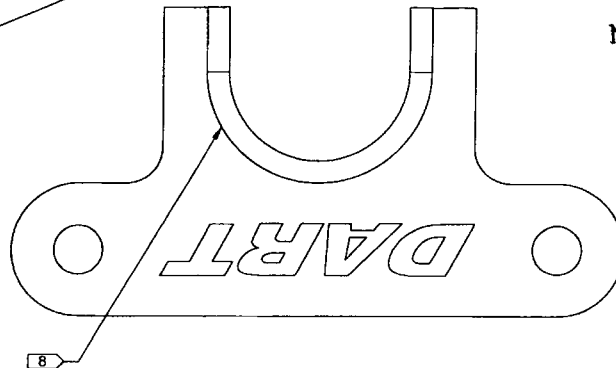
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3195-041 BRACKET

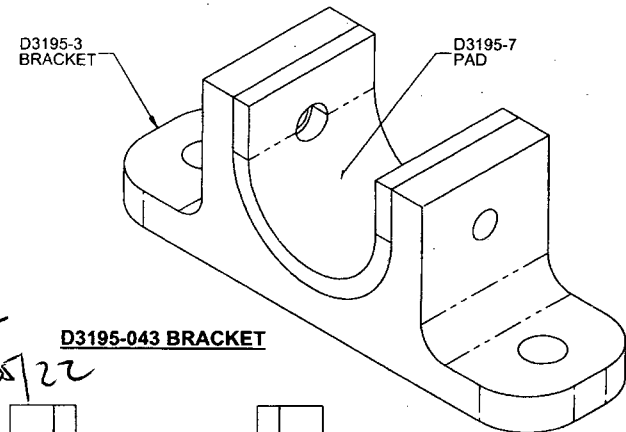


ITEM	QTY -041	P/N	DESCRIPTION
	X	D3195-041	BRACKET
1	1	D3195-1	BRACKET
2	1	D3195-5	PAD

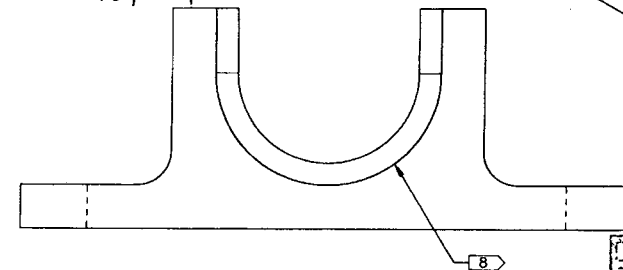
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3195-04X" AND BATCH NUMBER "BXXXXX" PER QSI044 METHOD 6.1
- 7) WEIGHT: D3195-041: 0.15 lbs
D3195-043: 0.14 lbs
- 8) BOND PAD TO BRACKET USING 3M SCOTCH-WELD HIGH PERFORMANCE 1300/1300L (OR EQUIVALENT)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04756 MLJ
12/07/22



D3195-043 BRACKET



ITEM	QTY -043	P/N	DESCRIPTION
	X	D3195-043	BRACKET
1	1	D3195-3	BRACKET
2	1	D3195-7	PAD

RELEASED
2012-04-30

B	- UPDATED DRAWING FORMAT. - ADDED NOTE 8, SHEET 1. - D3195-5 & D3195-7 DIMENSIONS EXTENSIVELY REVISED (06-3, C3-3) - REF: PAR11-130		RP	12.04.13
A	NEW ISSUE		CP	03.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RP			
CHECKED	A.P.	DRAWING NO.	REV. B	
MFG. APPR.	E	D3195	SHEET 1 OF 3	
APPROVED	W	TITLE	SCALE	
DE APPR.	CH	BRACKET	NTS	
DATE	12.04.13	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

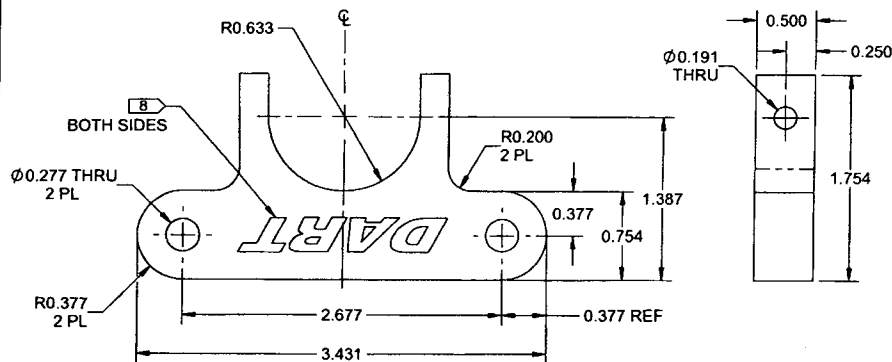
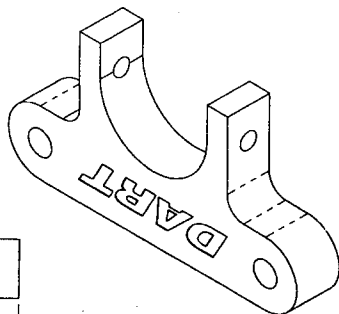
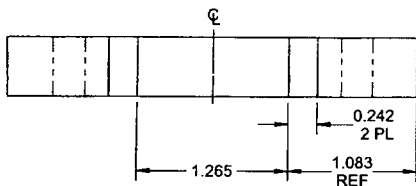
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

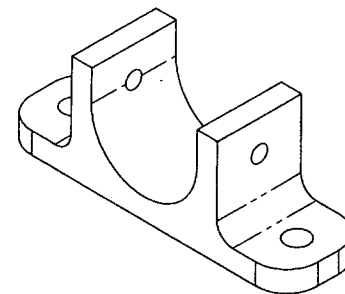
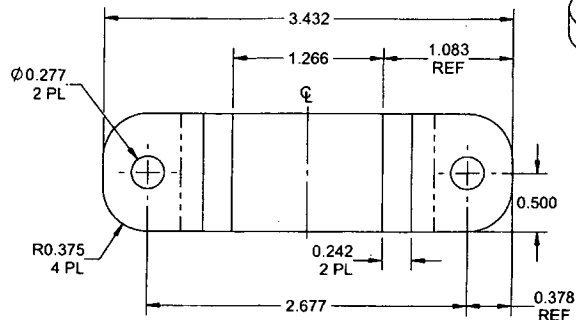
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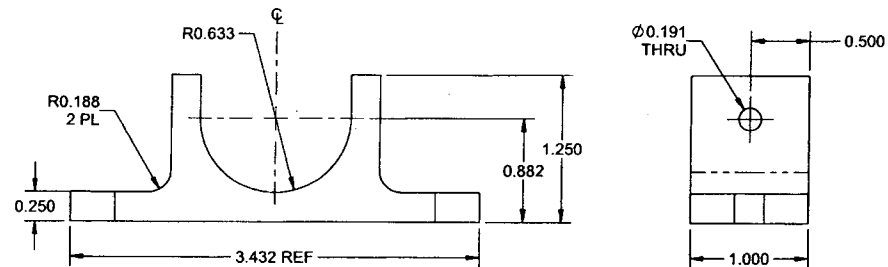
NOTE: Date & initial all entries



D3195-1 BRACKET



24756



D3195-3 BRACKET

RELEASED
2012-04-30

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDING (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3195-1 0.15 lbs
D3195-3 0.14 lbs
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.28 HIGH X 0.005 DEEP LETTERING (TYPICAL BOTH SIDES)

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	JP	D3195	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BRACKET	NTS
DATE	12.04.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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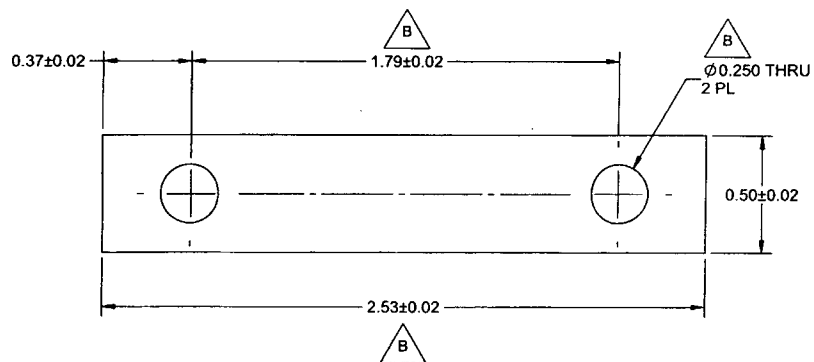
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

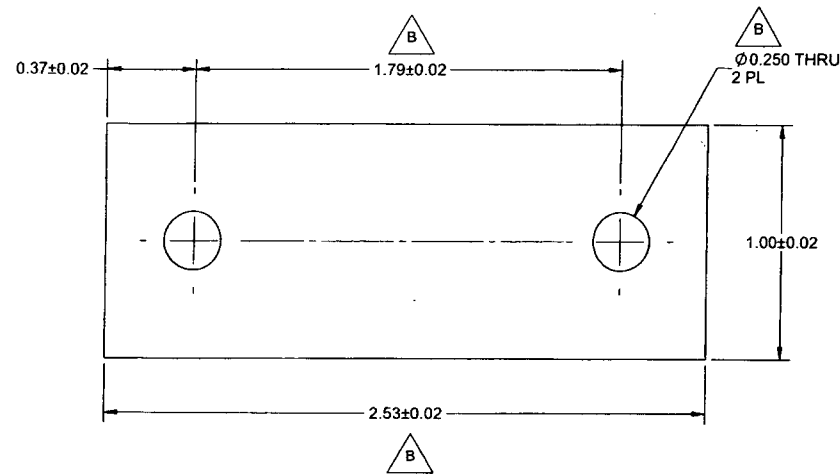
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

24756



D3195-5 PAD



D3195-7 PAD

RELEASED
2012-04-30

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/8" THICK, 60 DUROMETER
(REF DART SPEC M-NEO60-S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>A.P.</i>	DRAWING NO. D3195	REV. B
MFG. APPR.	<i>E</i>	SHEET 3 OF 3	
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>#</i>	BRACKET	NTS
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DART AEROSPACE LTD		Work Order: 84756
Description: BRACKET		Part Number: D3195-3
Inspection Dwg: D3195	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3,432	± 0,010	3,432	✓		VERN	PHD-01
1,266	± 0,010	1,264	✓		"	"
1,083	± 0,010	1,088	✓		"	"
0,500	± 0,010	0,498	✓		"	"
0,378	± 0,010	0,375	✓		"	"
0,242	± 0,010	0,242	✓		"	"
2,677	± 0,010	2,676	✓		"	"
R0,375	± 0,010	0,375	✓		Rad gauge	
R0,633	+0,008 -0,001	0,632	✓		VERN	PHD-01
0,882	± 0,010	0,880	✓		"	"
1,250	± 0,010	1,251	✓		"	"
0,250	± 0,010	0,252	✓		"	"
R0,188	± 0,010	0,188	✓		"	"
0,500	± 0,010	0,499	✓		"	"
1,000	± 0,010	1,001	✓		"	"
Ø 0,277	+0,003 -0,001	0,277	✓		"	"
Ø 0,191	+0,003 -0,001	0,193	✓		"	"

Measured by: P/B	Audited by: [Signature]	Prototype Approval: N/A
Date: 12/06/04	Date: 12/06/05	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	